

# Work Order ID 57194

Monday, March 29, 2010 9:54:55 AM



HAC

Page 1

Item ID: D3910-1

Accept



Setup Start



Revision ID:

Item Name: Crosstube Lug

Stop



Start Date: 3/29/2010 Start Qty: 4.00

Cust Item ID:

Required Date: 4/2/2010 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan: MF

Date: 10-3-29

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3910

B

100

0.00



Bandsaw

Memo

0.00

Jeaspa Bandsaw

CUT BLANK 1.450" LONG

MMW 10/03/29

20 8

110

0.00



HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

MACHINE AS PER FOLIO FA865 AND DWG

FOLIO REV: AA

DWG REV: B

DJP 10/03/30

20

DEBURR

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

**Work Order ID 57194**

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Page 2

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Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QS1005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing



Setup Start



Stop



Cust Item ID:

Customer:

Run Start



Stop



DIT 10/03/30

20

SF 10/03/31

20

HJ 10/03/31

20 0

W/O:		WORK ORDER CHANGES					
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Page 4

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

Pull on  
00702  
x  
4  
mf  
10-4-5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**NOTE:** Date & initial all entries



# Picklist Print

Monday, March 29, 2010 9:54:55 AM

Page 1

Work Order ID: 57194



Parent Item: D3910-1



Parent Item Name: Crosstube Lug

Start Date: 3/29/2010



Required Date: 4/2/2010

Comments: IPP REV:A NEW ISSUE 09-11-25 JLM VERIFIED BY:DD  
REV:B AS PER REV B 10-03-23 JLM VERIFIED BY:DD

IPP

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2423		Manufactured	No			100	f	560.8751	0.5474			
												
Lug Extrusion												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT06	560.8751432	
43722	173.462806	
44529	5.7731	
45800	381.639237	

45800

JFS 10/04/01

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

DART AEROSPACE LTD		Work Order:	57194
Description: <i>Crosstube Lug</i>		Part Number:	D3910-1
Inspection Dwg: D3910-1 Rev: R		Page 1 of 1	

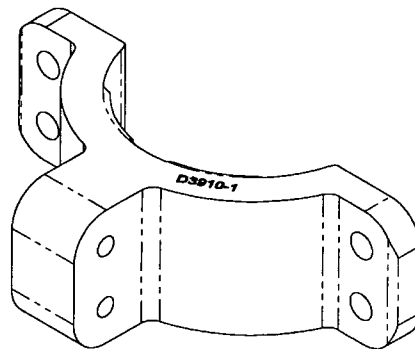
### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

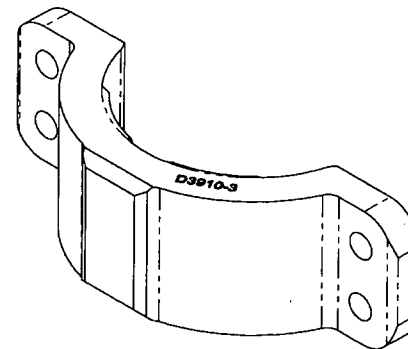
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.45	$\pm 0.030$	4.454	✓			
1.38	$\pm 0.030$	1.38	✓			
R0.080	$\pm 0.020$	0.070	✓			Round Edge 2PL
0.27	$\pm 0.030$	0.275	✓			REF
0.31	$\pm 0.030$	0.303	✓			
R1.20	$\pm 0.030$	1.20	✓			
0.735	$\pm 0.010$	0.725	✓			REF
0.375	$\pm 0.010$	0.376	✓			
3.700	$\pm 0.010$	3.700	✓			
$\phi 0.257$	$+0.006/-0.001$	0.259	✓			4PL
R0.34	$\pm 0.030$	0.34	✓			TYP
0.375	$\pm 0.010$	0.373	✓			
0.625	$\pm 0.010$	0.623	✓			
2.20	$\pm 0.030$	2.20	✓			
0.375	$\pm 0.010$	0.374	✓			
0.38	$\pm 0.030$	0.374	✓			
0.625	$\pm 0.010$	0.623	✓			
R0.38	$\pm 0.030$	0.38	✓			2PL
$\phi 0.191$	$+0.005/-0.001$	0.193	✓			2PL

Measured by: <i>DJD</i>	Audited by: <i>J.F</i>	Prototype Approval:	N/A
Date: 10/03/30	Date: 10/03/31	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



**D3910-1 X-TUBE LUG**



**D3910-3 X-TUBE LUG**

**RELEASED**  
2010-03-22  
MD

57194

**NOTES:**

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF  $0.010 \pm 0.005$  IN THIS LOCATION WITH A TOOL TIP RADIUS  
OF  $0.015 \pm 0.005$
- 7) WEIGHT -1: 0.32 lbs  
-3: 0.25 lbs

B	Ø0.257 HOLES: 4 PL WAS 2 PL (A3-2) & (A3-3); R0.34 FILLET WAS R0.50 (A3-2) & (A3-3). REASON: SEE TR-D390-007-2	JPH	10.03.16
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3910	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		X-TUBE LUG (350)	NTS
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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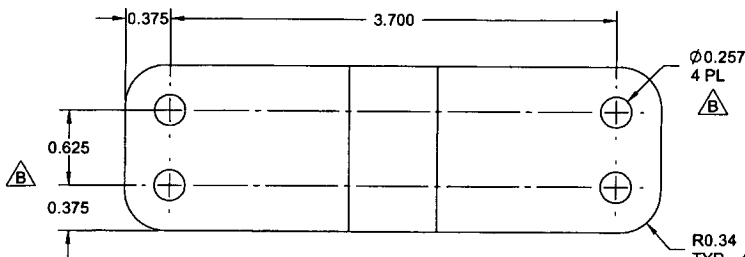
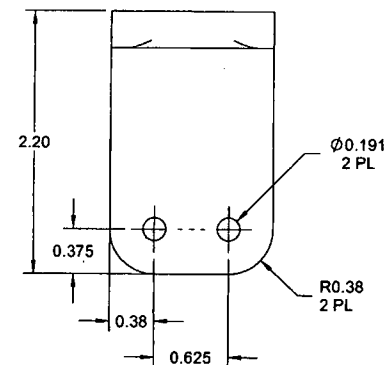
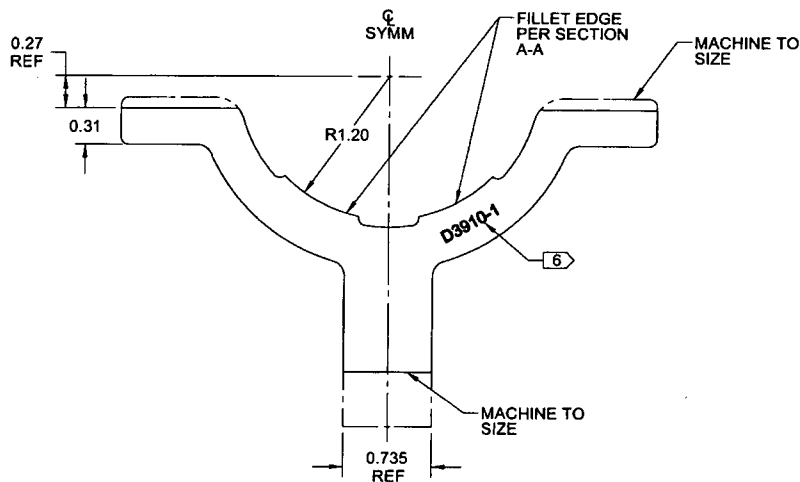
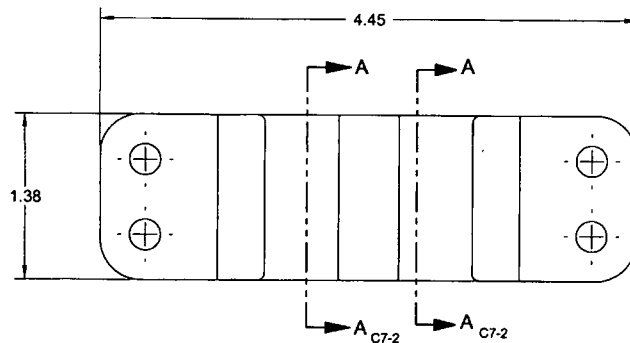
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**SECTION A-A**  
C4-2  
CS-2



ROUND EDGE  
R0.06 MIN - R0.10 MAX  
2 PL



**D3910-1 X-TUBE LUG**

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO. <b>D3910</b>	REV. B
MFG. APPR.		TITLE <b>X-TUBE LUG (350)</b>	SHEET 2 OF 3
APPROVED		SCALE NTS	
DE APPR.		COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	10.03.16		

**RELEASED**  
2010-03-22

57194

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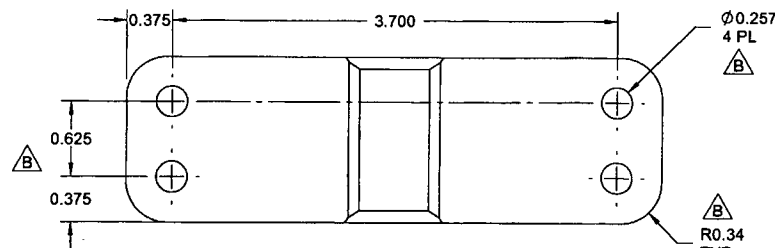
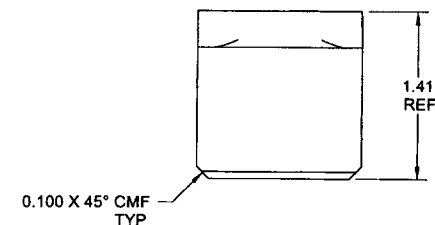
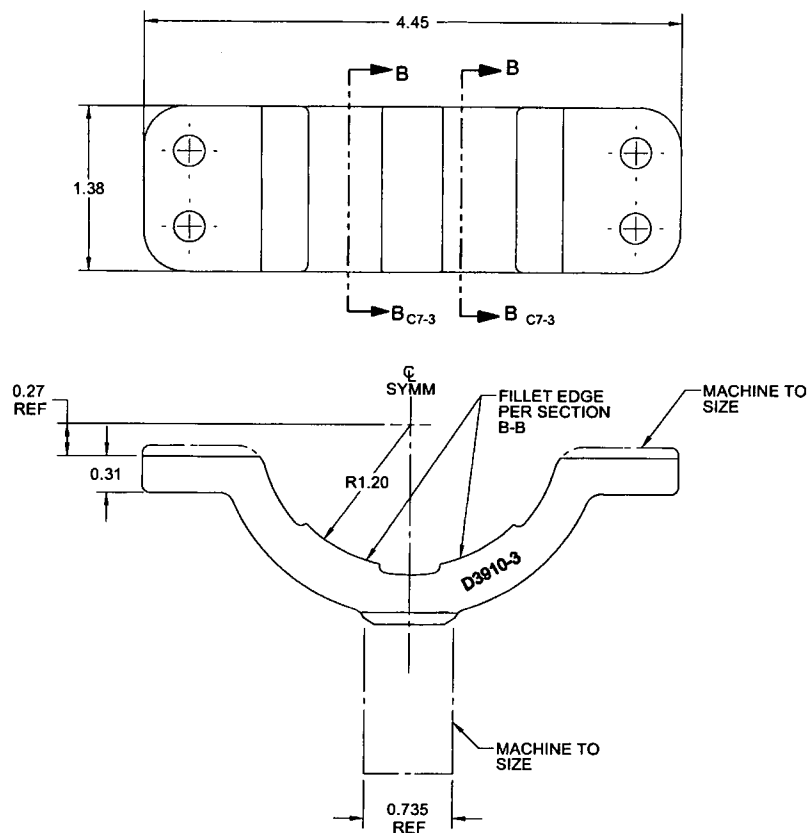
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**SECTION B-B**  
C4-3  
C5-3



ROUND EDGE  
R0.06 MIN - 0.10 MAX  
2 PL



**D3910-3 X-TUBE LUG**

57194

**RELEASED**  
2010-03-22

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3910	REV. B
MFG. APPR.		TITLE	SHEET 3 OF 3
APPROVED		X-TUBE LUG (350)	SCALE
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